

What is claimed is:

1. A method for laser welding comprising:
 - 5 forming a laser-transmissible resin workpiece exhibiting whitish hue of white, gray or tint color out of a resin composition which includes 100 parts by weight of a thermoplastic resin and 0.1 to 2 parts by weight of white pigment having 2 to 2.8 of reflectance,
 - 10 piling a resin workpiece being at least partly capable of laser-absorption onto the laser-transmissible resin workpiece,
 - 15 and then irradiating a laser beam thereto to weld them thermally.
2. The method for the laser welding according to claim 1,
 - 15 wherein the resin workpiece being at least partly capable of the laser-absorption is formed out of a resin composition which includes 99.1 to 98 parts by weight of a thermoplastic resin and 0.1 to 2 parts by weight of white pigment having 2 to 2.8 of reflectance, and exhibits whitish hue of white, gray or tint color.
- 20 3. The method for the laser welding according to claim 1,
 - wherein the resin workpiece being at least partly capable of the laser-absorption comprises a laser-absorptive layer including an laser-absorbent being capable of laser-absorption under region
 - 25 of wavelength of 800 to 1200 nm at least partially and a whitish resin material that the layer is applied thereto.

4. The method for the laser welding according to claim 1,
wherein the laser-transmissible resin workpiece has 1.5 to 1.8 of
the reflectance.

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5. The method for the laser welding according to claim 3,
wherein a color difference: ΔE between the laser-transmissible
resin workpiece and the whitish resin material of the resin
workpiece being at least partly capable of the laser-absorption is
10 at most 0.3.

6. The method for the laser welding according to claim 1,
wherein an average particle size of the white pigment in the
laser-transmissible resin workpiece is 100 to 300 nm.

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7. The method for the laser welding according to claim 3,
wherein the laser-absorptive layer is prepared by applying ink
and/or paint including the laser-absorbent.

20 8. The method for the laser welding according to claim 7,
wherein a principal solvent in the ink and/or the paint is an
alcohol solvent or a glycol solvent.

25 9. The method for the laser welding according to claim 3,
wherein the laser-absorptive layer is a resin film including the
laser-absorbent.

10. The method for the laser welding according to claim 3,
wherein the laser-absorbent is carbon black and/or nigrosine.

5 11. The method for the laser welding according to claim 1,
wherein the laser beam is irradiated with scanning, and furnishes
an energy quantity: x (J/mm) that satisfies the following numerical
expression

$$x = \frac{p \times T}{100 \times q} \geq 0.9$$

10 [in the numerical expression, p (W) is output power of the laser
beam, q (mm/sec.) is scanning speed of the laser beam, T is
transmittance of the laser-transmissible resin workpiece under
wavelength of the laser beam].